

Work Order ID 115516

Wednesday, April 02, 2014 11:27:25 AM

115516

Ship Friday April 11th
Page 1

Item ID: D500-560-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cargo Mirror Installation
 Start Date: 4/2/2014 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 4/4/2014 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: WLF Date: 14-4-02 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev D								
100	Document Control	0.00	DAS						
100	DOCUMENT CONTROL		03						
DC	Memo	0.00	9-89						
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D500-560-041 CHG006								
110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	Before assembly repass tap on stud. Assemble as per drawing D500-560 PAGE 8- BLUE FILE								
120	QC5- Inspect part completeness to step on W/O	0.00	DAS						
120			27						
QC	Memo	0.00	9-89						
Quality Control									

APR 09 2014

MJ 14-04-09

2

2

2

FF
14-04-09

2

14/4/9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Work Order ID 115516

Wednesday, April 02, 2014 11:27:25 AM

115516

Page 2

Item ID: D500-560-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Mirror Installation

Start Date: 4/2/2014 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 4/4/2014 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00				2x	DAS 28 9-89	APR 09 2014	
Packaging									
140	QC4- 100% Inspect kits for completeness	0.00							
140									
QC	Memo	0.00							
Quality Control									
150		0.00							
150									
Packaging	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D500-560-041								
	Location: _____								
	PPP Rev: _____								

DAS
06
9-89

APR 09 2014

DQA: _____ Date: _____



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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Page 3

Item ID: D500-560-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cargo Mirror Installation

Stop ***NS2***

Start Date: 4/2/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/4/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCJ 14-04-09

MCJ 14-04-09

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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Wednesday, April 02, 2014 11:27:23 AM

Page 1

Work Order ID: 115516

115516

Parent Item: D500-560-041

D500-560-041

Parent Item Name: Cargo Mirror Installation

Start Date: 4/2/2014

Required Date: 4/4/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E03.10.15Reformat; Removed D2057KJ/RF
IPP Rev:F 08-05-27 as per ECN1195p DD verified by:EC IPP Rev:G
10.04.22 chg route seq DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-4A *AN3-4A* Bolt		Purchased	No			140	Each	316.0000	4	8	DAS 28 9-89	APR 09 2014	
				<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>		
				ST350				200					
				m128429				100					
				m128634				100					
				ST511				116					
				m127044				116					
AN526C1032R10 *AN526C1032R10* Screw		Purchased	No			110	Each	27.0000	4	8		FF 14-04-09	
				<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>		
				FP001 128712				22					
				108062				22					
				ST346				5					
				m126857				5					
D1048 *D1048* Clamp		Manufactured	No			110	Each	10.0000	2	4		FF 14-04-09	
				<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>		
				GA 115372				10					
				106093				10					

DQA: _____ Date: _____



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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

Wednesday, April 02, 2014 11:27:23 AM

Page 2

Work Order ID: 115516

115516

Parent Item: D500-560-041

D500-560-041

Parent Item Name: Cargo Mirror Installation

Start Date: 4/2/2014

Required Date: 4/4/2014

Start Qty: 2.00

Required Qty: 2.00

D1049 Manufactured No 110 Each 34.0000 2 4

D1049

Saddle

FF 14-04-09

Location

Loc Qty

Loc Code

GA 115511
108735
112242
99603

34
4
20
10

4

D2010-101 Manufactured No 110 Each 28.0000 1 2

D2010-101

Mirror Bracket 369/500

FF 14-04-09

Location

Loc Qty

Loc Code

ST220
104401
105122
98507

28
3
24
1

2

D2010-103 Manufactured No 110 Each 1.0000 1 2

D2010-103

Mirror Arm 369/500

FF 14-04-09

Location

Loc Qty

Loc Code

ST220 104979
104241

1
1

2

D2011-101 Manufactured No 110 Each 41.0000 1 2

D2011-101

Mirror 6"

FF 14-04-09

Location

Loc Qty

Loc Code

FG
106348
ST179
110655
113569

2
2
39
16
23

2

Wednesday, April 02, 2014 11:27:23 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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FAULT CATEGORY

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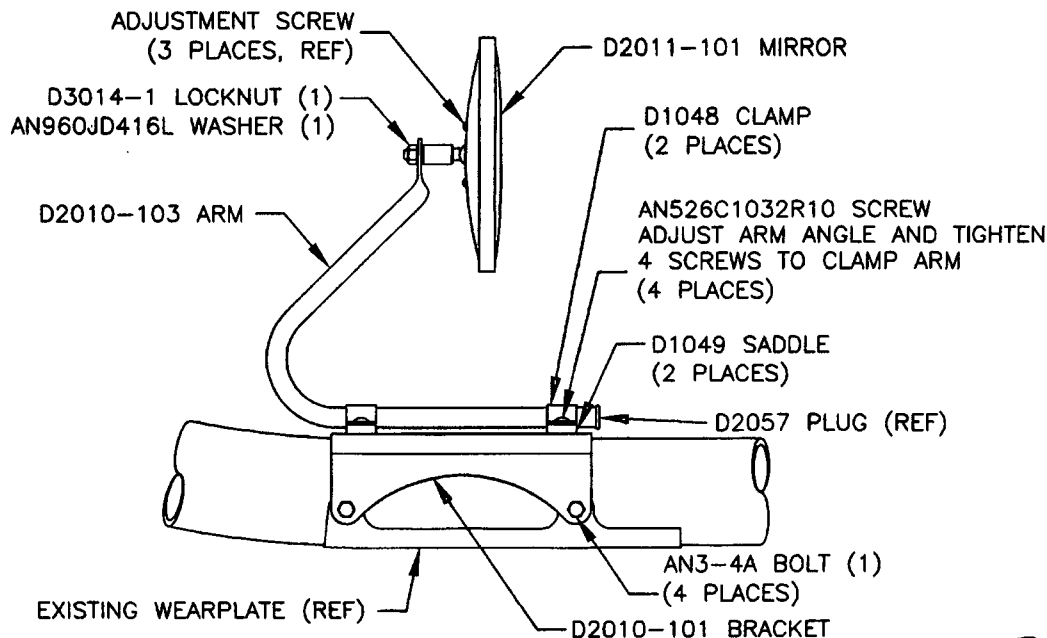


Figure 2: Installation of D500-560-041 Cargo Mirror Assembly

115576
14-4-02

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-560-041	1.0 lb	-45 in	-45 lb-kG	24 in	24 in-lb
Cargo Mirror Assembly	0.45 kg	-1.14 m	-0.51 m-kG	0.61 m	0.27 m-kG

5. PARTS LIST

Qty	Part Number	Description
X	D500-560-041	CARGO MIRROR ASSEMBLY
1	D2011-101	MIRROR
1	*D3014-1	LOCKNUT
1	*AN960JD416L	WASHER
2	D1048	CLAMP
2	D1049	SADDLE
1	D2010-101	BRACKET
1	D2010-103	ARM
4	AN3-4A	BOLT
4	AN526C1032R10	SCREW (OR AN526-1032R10)

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

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Revision: D

Date: 01.04.24

DQA: _____ Date: _____



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Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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